

Work Order ID 157140***157140***

Page 1

Tuesday, February 14, 2017 11:44:17 AM

Item ID: **D3053-042**

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: 212 Basket Base Assembly

Start Date: 3/20/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/28/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date: **FEB 14 2017**

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3053	C

100

0.00

100

Large Fab

Large Fab

Memo

0.44

Large Fab

1-Cut 5 D2235-3 FROM D3166-1 using **DT8365**

2-Cut Ribs from 3/4" x 3/4" x 0.065 wall 304/316 SS tubing as per dwg.

3-Remove all markings from material

4-Drill holes in D3053-3 as per dwg D3053

5-Drill holes in three D2235-3 ribs as per dwg D3053 using **DT8995**

6- Cut mesh as per dwg

1x DG 2017/03/21

110

Weld per dwg A/R S.S. rod Batch: **133989** 0.00***110***

Large Fab

Large Fab

Memo

0.00

Large Fab

1 -Weld as per Dwg D3053 using Welding Table and corner Jig Deburr as required

*1x C**18/03/27*DAS
43
9-89

MAR 31 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

157140

Tuesday, February 14, 2017 11:44:17 AM

N900040100

Stop *NS2*

Reference:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

120

Quality Control

① 17-04-05

DAS
9
9-89

130

Quality Control

D 17.04.05

DAS
9
9-89

140

Hand Finishing

(x1) ~~2~~ 2.12/04/10
BEB

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Page 3

Item ID: D3053-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 212 Basket Base Assembly
Start Date: 3/20/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/28/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel <i>M 136657</i> Memo START TIME: <i>1:40</i> OVEN TEMPERATURE: <i>400°</i> FINISH TIME: <i>2:10</i>	0.00 0.14				<i>1</i>	<i>0</i>	<i>17-04-10</i>	<i>33 989</i>
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00						<i>12 of 211 17/04/11</i>	<i>DAS 15 9-89</i>
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <i>w/c</i> Memo <i>17128</i>	0.00 0.00			<i>D205-541-04/B 157128</i>			<i>12 of 211 17/04/11</i>	

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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

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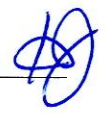
157140

Page 4

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.02							
Quality Control									

17/4/13 

DAS
21
9-89

APR 12 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Picklist Print

Page 1

Tuesday, February 14, 2017 11:44:21 AM

Work Order ID: 157140

157140

Parent Item: D3053-042

D3053-042

Parent Item Name: 212 Basket Base Assembly

Start Date: 3/20/2017

Required Date: 3/28/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP C02.09.04M304EX0.75-16F was M750-16FXS-S/SKJ/RF
IPP Rev:D 08-08-29 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D3166-1		Manufactured	No			100	Each	11.0000	5	5			
D3166-1									**			DC	2017/03/21
Basket Hoop													

Location	Loc Qty	Loc Code
WA004	11	B157365 → 5
146421	5	
153889	6	

✓ M304EX0.75-16F		Purchased	No			100	sf	1,038.300	48	50.52632			
M304EX0 75-16F									**			5/DC	17/03/27
Expanded Metal Flat SS													

Location	Loc Qty	Loc Code
WA004	1038.29996	
M136012	168.29996	
M136467	230	
M136612	640	

✓ M304TS0.750W.065		Purchased	No			100	f	762.4649	43.3333	45.614			
M304TS0 750W 065									**			DC	2017/03/20
304 SQ Tube .75x.75x.065W													

Location	Loc Qty	Loc Code
WA004	762.464944	B136907 → 49
m133412	2.264944	
m135655	400	
m136378	360.2	

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Parent Item: D3053-042

D3053-042

Parent Item Name: 212 Basket Base Assembly

Start Date: 3/20/2017

Required Date: 3/28/2017

Start Qty: 1.00

Required Qty: 1.00

D2232-3 Manufactured No

110 Each 25.0000 2 2

✓ ***D2232-3***

Basket Hinge

B158439 ** 2x C/P 17-3-29

Location

Loc Qty

Loc Code

WA004

25

141081

1

143693

1

148935

12

156858

11

D2327-3 Manufactured No

110 Each 63.0000 2 2

✓ ***D2327-3***

Spacer Bushing

** 17-3-23

Location

Loc Qty

Loc Code

WA004

63

148585

13

154190

50

D2581 Manufactured No

110 Each 82.0000 2 2

✓ ***D2581***

Mounting Bracket

** 17-3-30

Location

Loc Qty

Loc Code

WA004

82

132771

1

136270

2

139082

2

147603

2

148944

3

152803

48

155305

24

B156869

DQA: _____ Date: _____



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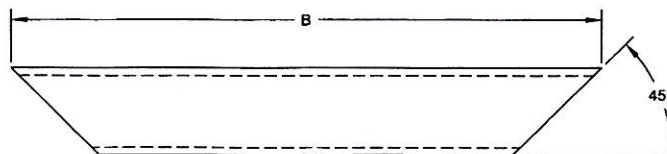
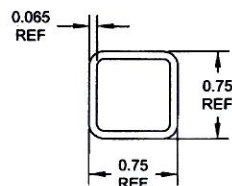
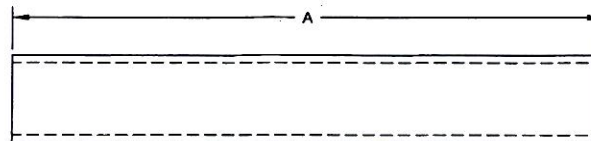
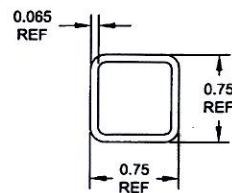
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Misidentified ☐	Past Due ☐																																																																

QTY -041	QTY -042	PART NO	LENGTH A	LENGTH B	DESCRIPTION
X		D3053-041	N/A	N/A	BASKET BASE ASSY
	X	D3053-042	N/A	N/A	BASKET BASE ASSY
2	2	D3053-1		96.00	RIB
2	2	D3053-3		25.50	RIB
6	6	D3053-5	23.73		RIB
3	3	D3053-7	25.31		RIB
3	3	D3053-9	19.48	N/A	RIB
2	2	D2327-3	N/A	N/A	BUSHING
2	2	D2581	N/A	N/A	MOUNTING BRACKET
2	2	D2232-3	N/A	N/A	HINGE PLATE
5	5	D2235-3	N/A	N/A	RIB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 157140

FEB 14 2017

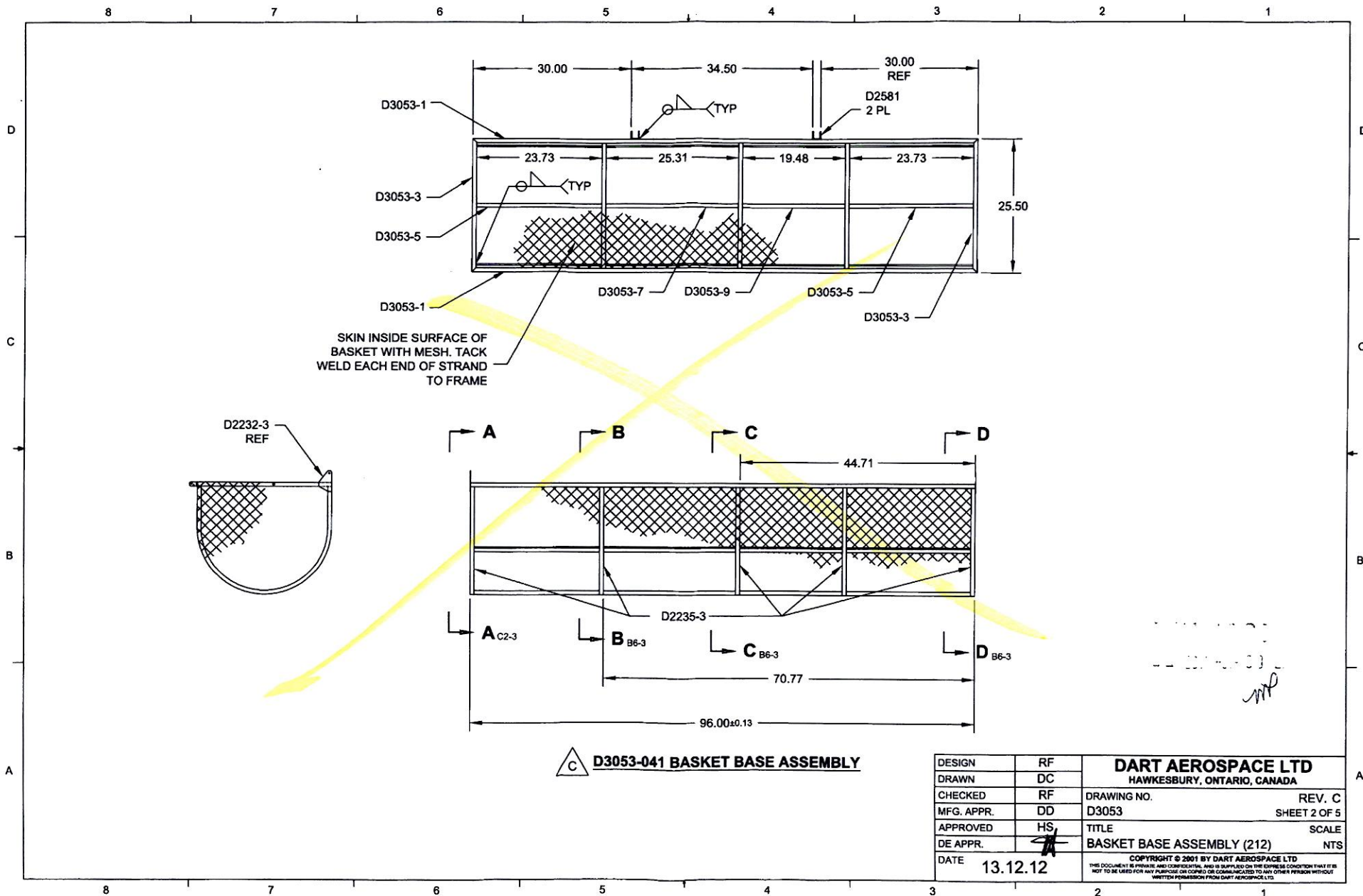


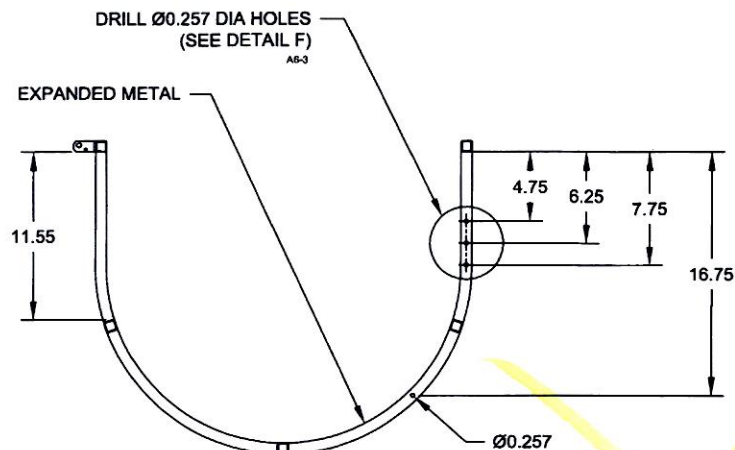
D3053-X RIB

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 10) WELD PER DART QSI 004

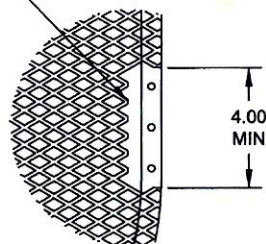
C	ADD -041 VIEWS, ZN B4-2, D4-2, B7-2, RE-ORGANIZE DWG. REF NCR13-2766.	DC	13.12.12
B	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS.	AJS	08.07.02
A	NEW ISSUE	RF	01.11.01
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D3053	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212)	NTS
DATE	13.12.12	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	





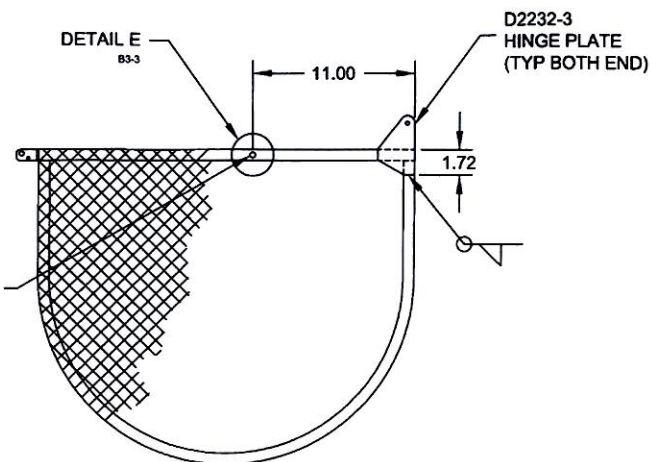
SECTION B-B_{B5-2}
SECTION C-C_{B4-2}
AND SECTION D-D_{B3-2}
RIB DETAIL

CUT AWAY EXPANDED
METAL TO NEAREST
INTERSECTIONS AS SHOWN
SECTION D-D ONLY

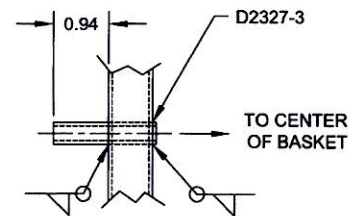


DETAIL F
SCALE NONE
C6-3

DRILL 3/8 HOLE
AND INSTALL
D2327-3 USING
CLOSEST SPACE IN
EXPANDED METAL
FOR HOLE LOCATION
BOTH ENDS



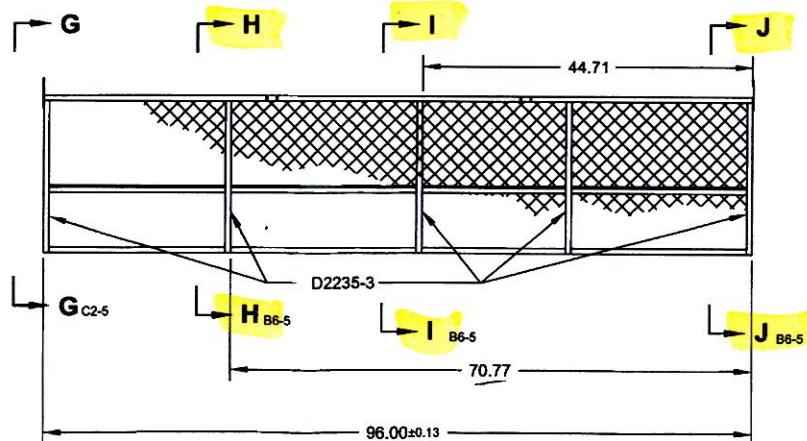
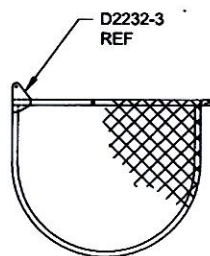
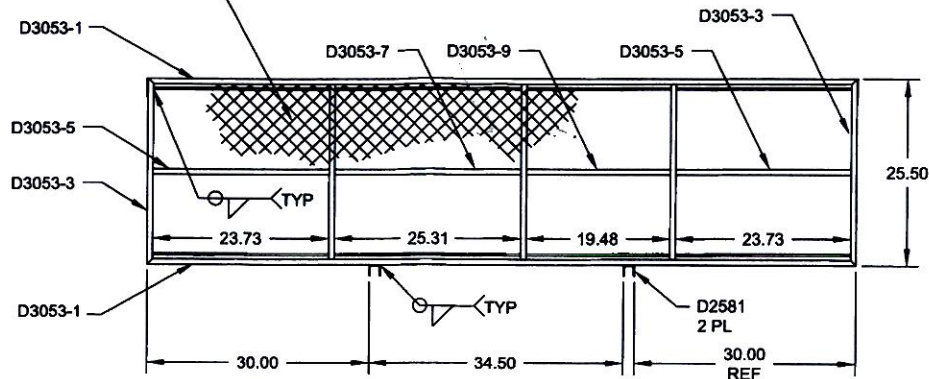
SECTION A-A
SPACER DETAIL
B6-2



DETAIL E
SCALE 4X
D2-3

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D3053	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212)	NTS
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SKIN INSIDE SURFACE OF
BASKET WITH MESH. TACK
WELD EACH END OF STRAND
TO FRAME



D3053-042 BASKET BASE ASSEMBLY SHOWN

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D3053	SHEET 4 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	BASKET BASE ASSEMBLY (212)	NTS
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